

606176 314

Split - 2

Work Order ID 125903 - 2

125903

Page 1

Item ID: D3490-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cross Bolt Spacer

Start Date: 10/27/14

Start Qty: 220.00

220

Cust Item ID:

Required Date: 11/28/14

Req'd Qty: 220.00

220

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-10-24

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3490

Rev A

100

100

Hardinge.CNC.LATHE.SMALL

0.00

DAS
40

DAS

37

9-89

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA629 & DWG D3490
FOLIO REV: 14/11
DWG REV: A
2-DEBURR AS REQUIRED

14/11/11

14-11-25

9-89 14-10-31

JFC 2014-11-21

110

110

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS

37

9-89

QC

Memo

0.00

Quality Control

14-11-25

9-89 14-10-31

120

120

QC8- Inspect parts - second check

0.00

DAS

40

9-89

QC

Memo

0.00

Quality Control

14-11-25

9-89 14-10-31

485

Work Order ID 125903

Friday, October 24, 2014 11:12:01 AM

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Page 2

Item ID: D3490-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cross Bolt Spacer

Stop ***NS2***

Start Date: 10/27/14 Start Qty: 220.00

220

Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 220.00

220

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124		0.00							
124						116	0	14-12-05	BE
HandFinish	Memo	0.00							
Hand Finishing	CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER								

126

QC5- Inspect part completeness to step on W/O 0.00

126

QC

Memo 0.00

Quality Control

DD 14-12-5

130

Identify as per dwg & Stock Location: 26001 0.00***130***

Packaging

Memo 0.00

Packaging

STOCK IN SKIDTUBE CELL

116 0 BE 14-12-05

Work Order ID 125903

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Item ID: D3490-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cross Bolt Spacer
Start Date: 10/27/14 Start Qty: 220.00 ***220*** Cust Item ID:
Required Date: 11/28/14 Req'd Qty: 220.00 ***220*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/12/18 *[Signature]*

[Signature] 12-05

Picklist Print

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Page 1

Work Order ID: 125903

125903

Parent Item: D3490-3

D3490-3

Parent Item Name: Cross Bolt Spacer

Start Date: 10/27/14

Required Date: 11/28/14

Start Qty: 220.00

Required Qty: 220.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	53.4941	0.266	62			
M6061T6R0 750												DAS	
6061-T6 Round Bar .750"												37	
												9-89	14.10.31

Location	Loc Qty	Loc Code
MAT012	53.494052	
m126852	3.494052	
m130043	2	
m130527	48	
M130745		
M128573		

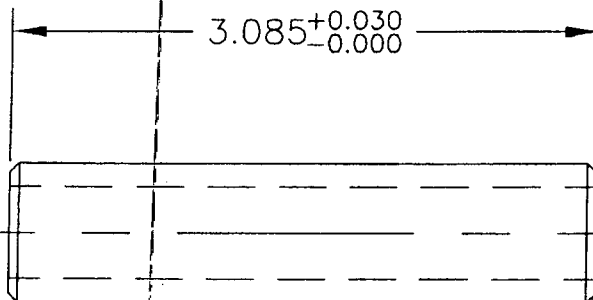
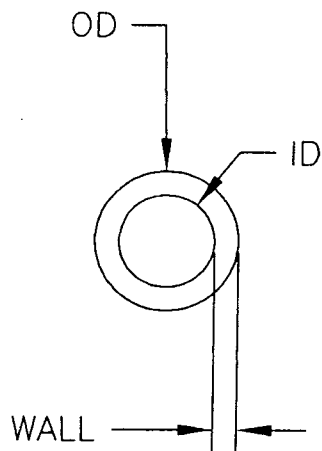
DAS
37
9-89
14.11.25

1.0 ft.
30.4 ft.
29.6 ft.
1.0 ft.

M130043 1.0 ft.
M128573 1.0 ft.
M130745 12.0 ft. 17 ft 5.6 ft.
M130527 1.6 ft.
6.0 ft.
4.0 ft.
8.0 ft.
12.0 ft.
2.0 ft.



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER SCALE NTS	
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

[Handwritten signature]
14-10-24
125903

RELEASED
06-02-07

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